

Work Order ID 149350

Monday, July 25, 2016 1:23:57 PM

149350

DRA B GREEN

Page 1

Item ID: D3463-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Weldment Assembly

Start Date: 9/22/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: JUL 25 2016 Tooling:

Date:

Run Start

NR1

QC:

9-89

Date: SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.73

Large Fab

Weld assembly as per dwg D3463 using DT8875
***Leave a small none welded area on each side bottom of D3463-3 step to
drain water***

110

0.00

110

QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

120

0.00

120

QC

QC5- Inspect part completeness to step on W/O

Memo

0.03

Quality Control

8 16-09-21
JHDAS
9
9-89
③ 16-09-23DAS
9
9-89
③ 16-09-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 3

Item ID: D3463-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Step Weldment Assembly**Start Date:** 9/22/2016 **Start Qty:** 8.00***8*****Cust Item ID:****Required Date:** 9/30/2016 **Req'd Qty:** 8.00***8*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: GA

0.00

160

Packaging

Memo

0.01

Packaging

8x16/10/18
DAS 36 9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.13

Quality Control

DAS
21
9-89OCT 19 2016DAS
21
9-89OCT 19 2016

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WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 149350

149350

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 9/22/2016

Required Date: 9/30/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806		Purchased	No			100	Each	42.0000	2	16			
238-806									**				
SS DOWEL PIN 1" LONG													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 138623			42		8			
					M127628			42		8			
D3453-3		Manufactured	No			100	Each	14.0000	1	8			
D3453-3									**				
Clevis													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 149348			14		8			
					121222			3					
					121924			11					
D3453-5		Manufactured	No			100	Each	5.0000	1	8			
D3453-5									**				
Plug													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 149370			5		8			
					132561			1					
					147404			4					

DQA: _____ Date: _____



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Picklist Print

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Page 2

Work Order ID: 149350

149350

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 9/22/2016

Required Date: 9/30/2016

Start Qty: 8.00

Required Qty: 8.00

D3463-1 Manufactured No

100 Each

8.0000

1

8

D3463-1

Arm

16-09-19
JBL

Location

Loc Qty

Loc Code

WA001

149417

7

146737

3

146896

4

WA002

1

134861

1

8

D3463-3 Manufactured No

100 Each

6.0000

1

8

D3463-3

Step

16-09-21
JBL

Location

Loc Qty

Loc Code

WA002

149396

6

146876

6

8

D3463-5 Manufactured No

100 Each

7.0000

2

16

D3463-5

End Cap

16-09-21
JBL

Location

Loc Qty

Loc Code

WA002

149429

7

146909

7

16

D3463-7 Manufactured No

100 Each

6.0000

1

8

D3463-7

Drag Arm

16-09-21
JBL

Location

Loc Qty

Loc Code

WA002

149397

6

146885

6

8

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Shop Packet Print

Page 2

DQA: _____ Date: _____



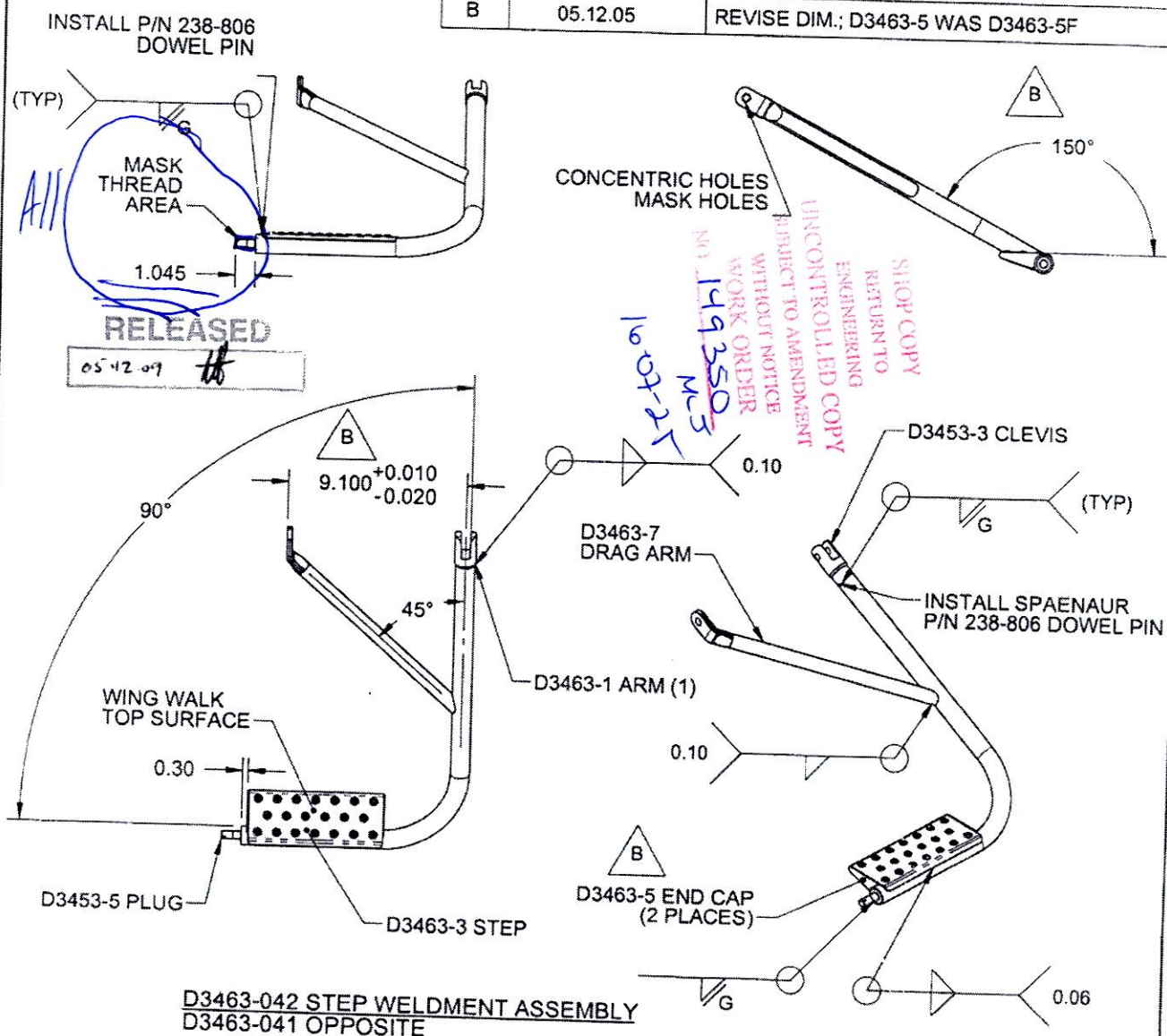
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		OTHER : ☐				

DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3463	
DATE		05.12.05		TITLE STEP WELDMENT	
A	05.09.20	NEW ISSUE			
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F			



- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

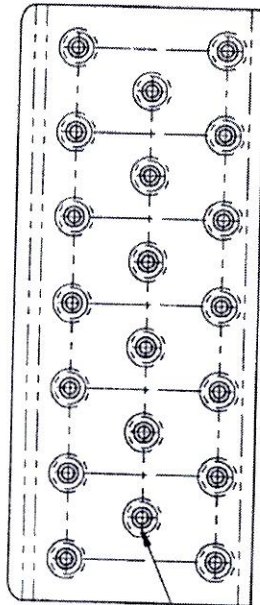
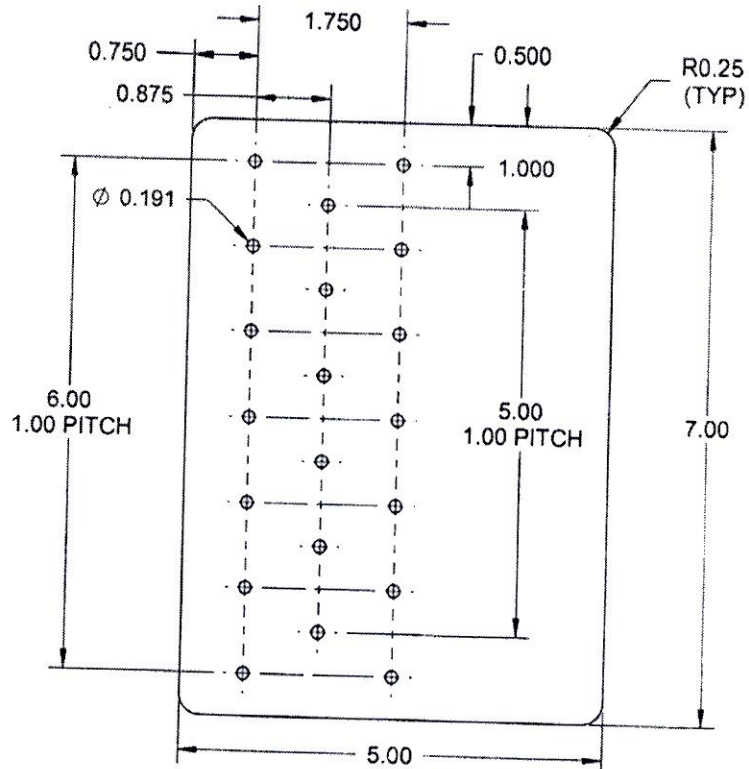
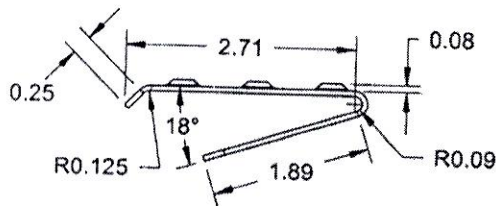
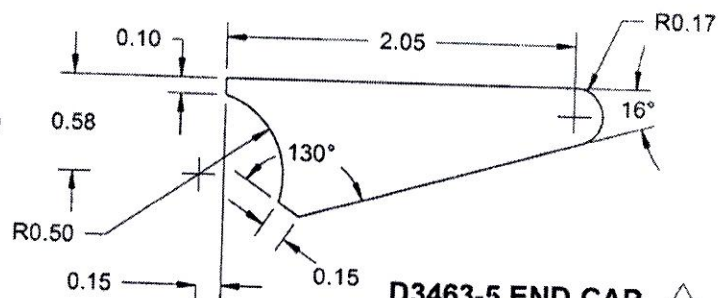
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B
DATE 05.12.05		TITLE STEP WELDMENT	SHEET 4 OF 4
			SCALE 1:2

RELEASED

05.12.05 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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